

Work Order ID 119435

November-18-14 2:43:11 PM

*Repair*

**\*119435\***

Page 1

Item ID: D3953-17 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Gas Spring Spacer  
 Start Date: 5/16/14 Start Qty: 30.00 **\*30\*** Cust Item ID:  
 Required Date: 5/16/14 Req'd Qty: 30.00 **\*30\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3953	C

100		0.00							DAS 23 9-89
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**\*100\***  
 Waterjet  
 FLOW CNC Waterjet

Memo  
 1-Cut as per Dwg D3953  
 Dwg Rev: C  
 Prog Rev: C

2- OPEN HOLES AS PER DWG  
 3- DEBURR IF NECESSARY

30 0 14-12-7

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
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**\*110\***  
 QC  
 Quality Control

Memo

30 0 14-12-7



# Work Order ID 119435

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**\*119435\***

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
<b>*120*</b>						(30)			
QC	Memo	0.00							
Quality Control									DEC 08 2014
130	Identify as per dwg & Stock Location: <u>4070</u>	0.00							DAS 46 9-89
<b>*130*</b>						(30)			DEC 08 2014
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

14/12/14  
 14-12-09



# Picklist Print

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Work Order ID: 119435

**\*119435\***

Parent Item: D3953-17

**\*D3953-17\***

Parent Item Name: Gas Spring Spacer

Start Date: 5/16/14

Required Date: 5/16/14

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.375X03.000

Purchased

No

100

f

15.5910

0.03125

①

DAS

**\*M304B0 375X03 000\***

**\*\***

**23**

**9-89**

14-12-7

M304 SS bar .375 x 3.00

Location

Loc Qty

Loc Code

MAT051

15.591

125340

6.26

m127501

3.64

m129891

5.691

129891



# Work Order Summary

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Criteria : Work Order ID: 119435 Item ID: D3953-17 Product Family MACHINING  
Work Order Start Dates 5/16/14 to 5/16/14 11:59:59 PM Work Order Required Dates 5/16/14 to 5/16/14  
11:59:59 PM

All References

Work Order Status Released

Work Order ID	119435	Required Qty	30.0000	Status Code	Released
Item ID	D3953-17	Accepted Qty	0.0000	Scrap Qty	0.0000

Item Name Gas Spring Spacer

Current Acct Value \$12.601

Start Date	5/16/14	Required Date	5/16/14	Completed Date
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Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **
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Direct Costs	Total	Each	Each	Each	Each
Material	\$0.000	\$0.000	\$0.456	\$0.456	100.00%
Labor	\$75.212	\$0.000	\$1.608	\$1.608	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$223.628	\$0.000	\$4.781	\$4.781	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$298.841	\$0.000	\$6.846	\$6.846	

Work Center Waterjet

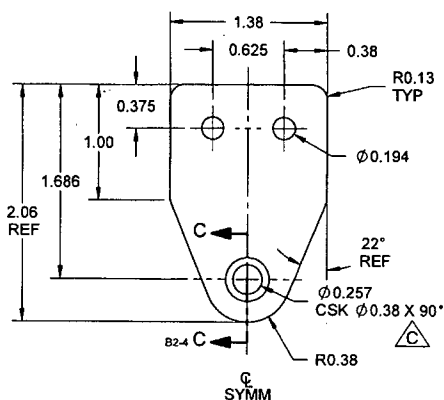
Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
MACL01												
9/12/14												
100			0.00	0.00	1.93	1.93	1.00	\$0.000	\$39.081	\$116.200	\$0.000	\$155.28
9/14/14												
100			0.00	0.00	1.79	1.79	1.00	\$0.000	\$36.131	\$107.428	\$0.000	\$143.56
Total:			0.00	0.00	3.72	3.72	2.00	\$0.000	\$75.212	\$223.628	\$0.000	\$298.84



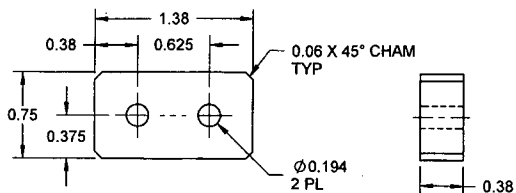




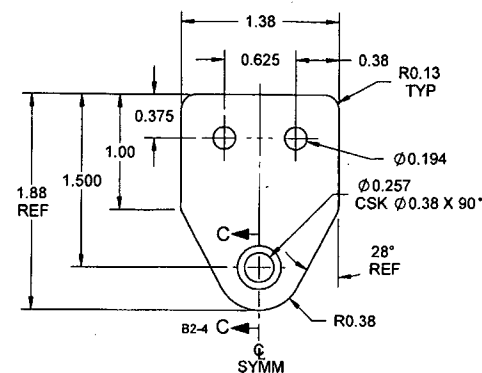




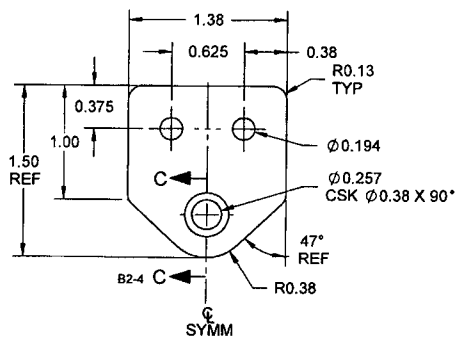
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



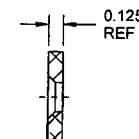
**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)



**SECTION C-C**

**RELEASED**  
2010-02-26

**NOTES:**

- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -15: 0.08 lbs  
-17: 0.10 lbs  
-19: 0.07 lbs  
-21: 0.06 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3953</b>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

